



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3914-041
Job Sheet 184110



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Large Fab-5		<i>Dr 0818-10-16</i>
100	Large Fab	1 pcs	10/31/18	10/31/18	0.00	6.67	Large Fab 1		<i>Dr 2018-10-23</i>
110	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC9		<i>CPC</i>
120	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC5		<i>CPC</i>
130	Powdercoat	1 pcs	10/31/18	10/31/18	0.00	0.40	Powdercoat4		<i>BR 18-11-01</i>
135	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC3		<i>AL 18-11-02</i>
140	HandFinish	1 pcs	10/31/18	10/31/18	0.00	0.80	HandFinish3		<i>AL 18-11-02</i>
150	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC3		<i>DR 18-11-2</i>
160	Packaging	1 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-2		<i>21ms NOV 02 2018</i>
170	QC21-SA	1 Ea	10/31/18	10/31/18	0.00	0.00	QC21		<i>2-01 NOV 02 2018</i>

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***

11/38839

START: 1:35

OUT: 8:00 FINISH: 2:05

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>5105222</i>
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5116508</i>
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5115924</i>
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	<i>5110932</i>
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	<i>5115926</i>
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	<i>5113739</i>
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	<i>5114287</i>
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	<i>5114841</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
-----------	----------------	----------	-----------	-----------

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER :							

90-Start up Operation

D2581	2	76	0
D3914-1	2	5	0
D3914-7	2	10	0
D4016-3	3	195	0
D4018-5	9	42	0
D4020-5	1	10	0
D4021-3	1	33	0
D4035-043	2	16	0

Part Specifications

Specifications could not be found.

Plex 10/3/18 7:27 AM Dart.lajeunesse.marie

WORK ORDER

DISPOSITIO

Re

Use

Suspected Unapp

Description Work Order Deviation

Approval

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I